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RBE105-31781W2
Job Sheet 185442



Part No: RBE105-31781W2

Job Qty: 1 ea

Part Name: Milling Fixture



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/26/18

Job Tracking No:

Due Date: 11/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE105-31781W2 Rev.0 IPP Rev. A 18.10.24 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/16/18	0.00	0.00	Start Up Small Fab-2		MLL
110	Small Fab	1 pcs		11/16/18	0.00	1.00	Small Fab-3		MLL-DAS
120	QC	1 pcs		11/16/18	0.00	0.00	QC5		38
130	Packaging	1 pcs		11/16/18	0.00	0.00	Packaging3-1		Dart 9-89
140	QC21-FG	1 Ea		11/16/18	0.00	0.00	QC21		21 JAN 18 2019

Part Op 110 - 1-Assemble as per DWG. See note 1.
Descriptions:

GA141D

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBE105-31781W2-1	Base Assembly	1 Ea (1 ea)	90-Start up Operation	5145010
RBE105-31781W2-17	030.01 Cutter	1 Ea (1 ea)	90-Start up Operation	5139691
RBE105-31781W2-19	030.01 Holder	1 (1 ea)	90-Start up Operation	5138818
RBE105-31781W2-21	030.01 Pilot	1 (1 ea)	90-Start up Operation	5139819
RBE105-31781W2-23	020.01 Cutter	1 Ea (1 ea)	90-Start up Operation	5139682
RBE105-31781W2-25	020.01 Holder	1 (1 ea)	90-Start up Operation	5138820
RBE105-31781W2-27	020.01 Pilot	1 (1 ea)	90-Start up Operation	5138822
RBE105-31781W2-29	040.01 Cutter	1 Ea (1 ea)	90-Start up Operation	5139675
RBE105-31781W2-31	040.01 Holder	1 (1 ea)	90-Start up Operation	5138825
RBE105-31781W2-33	040.01 Pilot	1 (1 ea)	90-Start up Operation	5138830

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBE105-31781W2-1	1	0	0
	RBE105-31781W2-17	1	0	0
	RBE105-31781W2-19	1	0	0
	RBE105-31781W2-21	1	0	0
	RBE105-31781W2-23	1	0	0
	RBE105-31781W2-25	1	0	0
	RBE105-31781W2-27	1	0	0
	RBE105-31781W2-29	1	0	0
	RBE105-31781W2-31	1	0	0
	RBE105-31781W2-33	1	0	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

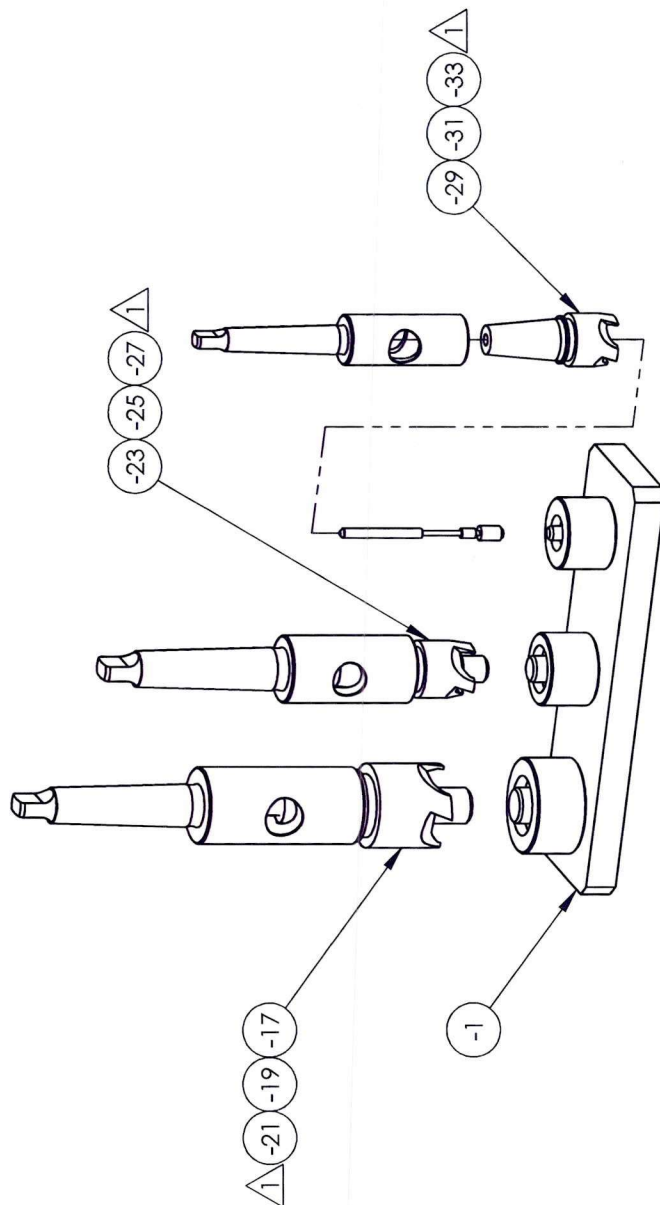
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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REV		ECR	REVISIONS		DESCRIPTION	DATE	INITIAL	APPROVED



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WITHOUT NOTICE
WORK ORDER

NO. 185448-105
18-10-26

NOTES:

1. TIGHTEN NUTS SO THE PILOT IS FLUSH BUT STILL ROTATES FREELY.
2. REF. EUROCOPTER/AIRBUS T/N 105-31781W2.



MILLING TOOL

ASSY QTY		B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BASE ASSEMBLY		(STEINER TECH/H. BILZ # R1000292) MODIFIED	2
			-3		BASE	6061	(STEINER TECH/H. BILZ # H1502)	3
			-5		020.01 BASE	6061	(STEINER TECH/H. BILZ # GZ1501500)	4
			-7		020.01 PIN	SS 303/304/316	(STEINER TECH/H. BILZ # R1000293) MODIFIED	5
			-9		030.01 BASE	6061	(STEINER TECH/H. BILZ # H1402)	6
			-11		030.01 PIN	SS 303/304/316	(STEINER TECH/H. BILZ # GZ1401100)	7
			-13		040.01 BASE	6061	(STEINER TECH/H. BILZ # R1000294) MODIFIED	8
			-15		040.01 PIN	SS 303/304/316	(STEINER TECH/H. BILZ # H1301)	9
			-17	1	030.01 CUTTER	STEEL	(STEINER TECH/H. BILZ # GZ1401100)	10
		B/O	-19	1	030.01 HOLDER	STEEL	(STEINER TECH/H. BILZ # H1502)	11
		B/O	-21	1	030.01 PILOT	STEEL	(STEINER TECH/H. BILZ # R1000293) MODIFIED	12
		B/O	-23	1	020.01 CUTTER	STEEL	(STEINER TECH/H. BILZ # H1402)	13
		B/O	-25	1	020.01 HOLDER	STEEL	(STEINER TECH/H. BILZ # GZ1401100)	14
		B/O	-27	1	020.01 PILOT	STEEL	(STEINER TECH/H. BILZ # R1000294) MODIFIED	15
			-29	1	040.01 CUTTER	STEEL	(STEINER TECH/H. BILZ # H1301)	16
		B/O	-31	1	040.01 HOLDER	STEEL	(STEINER TECH/H. BILZ # GZ1300600)	17
		B/O	-33	1	040.01 PILOT	STEEL	(STEINER TECH/H. BILZ # H1301)	18

DWG NO.		REV
RBE105-31781W2		

TITLE	
MILLING TOOL	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS $\pm$ 1/8	
.XXX $\pm$.005	ANGLES $\pm$.5°
.XX $\pm$.01	SURFACES = 125/
.X $\pm$.1	

DRAWN BY:	MACKOVJAK
CHECKED:	
OPPS APPR:	
QA APPR:	
APPROVED:	

SCALE	1:3	DATE	04/08/2017	SHEET 1 OF 12
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CANADA
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www.dartaerospace.com

Container No: S145456



Part: RBE105-31781W2

Job No: 185442

Serial No/Batch: S145456

Revision: 0

Inspector:

Exp Date:

Instructions:

Date: 01/16/19